	Vork Order ID 106385  129:13 1:36:47 PM			*106385*							Page 1
Revision ID:	D3200-3  Door Wedge			Accept	*N900	<b>040</b>	100	<b>)*</b> s	Setup Start	IV	S1* S2*
Start Date: Required Date: Reference:		Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:					
Approvals:	Process Plan	: _MCJ	Date: \\\ \]_\(\)\\\\ \\ \]	_		ate:		ŀ	Run Star Stop	1/1	R1* R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Pian Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revis	sion Nbr									
D3200	Rev A	4				<u></u>					
*100 *100*		BAND SAW		0.00	174 B/0	1/06		<u>Jo</u>	× 	·	·
Bandsaw Jeaspa Bandsaw		Memo Cut blank: 1	1.000 X 1.970"	0.00						<i>y</i>	1
110		ALA AG CNO MEDITICAN	NACHINING #1	0.00	. /.				0		1
*110* HAAS I HAAS CNC vertical		HAAS CNC VERTICAL  Memo  I-Machine		0.00 337 and Dwg D32002-Deb	DR/D., 13/09/08			20	<u> </u>		
120		QC2- Inspect parts off n	nachine FAI/FAIB	0.00	1				,		·
*120* QC Quality Control		Мето		0.00	De /D.a 13/09/08			20	_Ø		_ +

											DQA:	Dat	e	
NCR:	Yes	/ No				WORK ORDER NON-C	COI	NFORM	MANCE / UPDATE		QA Closed:	 Dat	e:	
Work Orde	~ = .					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No.  NCR No.						Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other	
Root					Descri	ption of work order update		Initial	Action		Sign &		Ī	
Cause	Ì	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Description		Date	Verification	ı [	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
		_					AUI	LT CATE	GORY					
Landing Gear						General	_	1			1	г		- 4
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs				Bend BOM/Route Broken/Damaged Burrs Contamination		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	it .		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
	Heat Treat					Countersink	1	Mislaholed			Positioned V	Vrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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	Work Order ID 106385 [ugust-29-13 1:36:47 PM]		*106385*								· <del>- 2.244.</del>	Page 2
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D3200-3  Door Wedge 8/29/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*	Accept	C	Ust Item II		100	)* 5	Setup Star Stop	1.71	S1* S2*
Approvals:		in:	Date:			Da	te:	· · · · · · · · · · · · · · · · · · ·	ļ	Run Star Stop		R1* R2*
Sequence ID/ Work Center II 130 *130* QC Quality Control	D	Operation Description QC8- Inspect parts - secon	nd check	Set Up/ Run Hours 0.00	OAS )	(3/c	Tool#	Plan Code	Accept Qty ZO	Reject Qty	Reject Number	Insp. Stamp
140 *140* Packaging Packaging		ldentify as per dwg & Sto	ck Location: <u>STO3</u> 3	0.00					_20 x	28	13-09	-10
150 *150* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00						13/	<u> 4/11</u>	4)

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NCR:	Yes	/	No

DQA:

Date:

NCR: Y	es / No				WORK ORDER NON-	CONFOR	MANCE / UF	DATE				
									QA Closed:	Date	<u>:</u>	•
Work Orde	r.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS		
WOIK Of GC	'				Rework	7 J	Skid-tube	Crosstube	]	Water Jet	Engineering	
Part N	٥.				Scrap	1 1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
, 2, 1, 1					Use-as-is	The	moforming	Finishing	Rec/Sto	re/Packaging	Other	
NCR N	o.				Work Order Update	]	Large Fab	Composite		Supplier		
			·							, · · · · · · · · · · · · · · · · · · ·	<del></del>	
Root					ption of work order update	Initial	1	ction	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector	-
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Landin	ng Gear	2.5		<b>_</b> -	General			<u>-</u>	7	_	¬	
L	Bending			<u> </u>	Bend	Grain		_	Ovalized	-	Pressure/Forced	
]	Centre 1	Not Conce	ntric to C	)/S	BOM/Route	Hardy		ļ	Over/Under	_	Temperature/Cure	
1	Cracks				Broken/Damaged	<b>⊢</b>	ction incomplete	<u> </u>	Part Incorre	_	Weld	
Į	Crushed	l/Crimped		_	Burrs	$\vdash$	ctions Incomplete	/Unclear	Part Lost/M	_	Wrong Stock Pulled	
[	Cuffs				Contamination	— —	tenance	ļ	Part Moved			
[	Heat Tre	eat			Countersink	Misla	beled	<u> </u>	Positioned \	_	<b>-</b> 1	
[	Inspecti	on Strip in	Tube		Cut Too Short	Misre	ad	_	Power Loss/	/Surge	Other	
	Ripples	in Bend			Drill Holes	Offse	t					
ſ	Torque	Waves in I	Extrusion	ı [	Drawing	Out o	f Calibration					
	Turning	Sequence	•		Finish	Out o	f Sequence				······································	
Wave/Twist in Tube				Folio	Outsi	de Dimensions						

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August-29-13 1:36:47 PM

Work Order ID:

106385

Parent Item:

D3200-3

Parent Item Name:

Door Wedge

Start Date: 8/29/13

Required Date: 8/29/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No		-	100	sf	607.0003	0.015	0.31579			·
				<b>Location</b>		Loc Oty	<u>Lo</u>	<u>e Code</u>				ı,	. !
				MAT019		607.0002895					H BI	09/04	
				- 1212	78	11.0002895			_ / 3	1579	Hi		
				1225	75	47.6							
				12322	29	53							
				12370	0.4	63.8							

6.96 197.12

17.52

210

123704 123949

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125137

CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
										QA Closed:	D	ate:	
or.					DISPOSITION				AGAINST DI	EPARTMENT,	/PROCESS		
lo					Rework Scrap Use-as-is	1	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing			d. Eng. Coor re/Packaging		Engineering Quality Other	
اo					Work Order Update		1	Large Fab	Composite	_	Supplie	r	Ц
	Date	Step	Qty		•	-				Sign & Date	Verification	on	QC Inspector
						FAU	LT CATE	GORY		·			
Landing Gear  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Wayes in Extrusion			General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset			Part Incorre Part Lost/M Part Moved Positioned V	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
	ng Ge	Date  Date  Date  Date  Cracks Crushed/ Cuffs Heat Treat Inspection Ripples in	Date Step  Date Step	Date Step Qty  Date S	Date Step Qty  Date Step Qty  Region Concentric to O/S  Cracks  Crushed/Crimped  Cuffs  Heat Treat  Inspection Strip in Tube	DISPOSITION  Rework Scrap Use-as-is Work Order Update  Date Step Qty Description of work order update or Non-conformance  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend  DISPOSITION  Rework Scrap Use-as-is Work Order Update or Non-conformance  Bend Bend Bend Bend BoM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes	Part Step Qty Description of work order update or Non-conformance Company Containing Centre Not Concentric to O/S Cracks Broken/Damaged Cushed/Crimped Burrs Contamination Cuffs Heat Treat Countersink Cushes Inspection Strip in Tube Ripples in Bend Drill Holes	Part Cate    Control Not Concentric to O/S   Bom/Route   Cracks   Crushed/Crimped   Cushed/Crimped   Cushed/	DISPOSITION  Rework Scrap Wase-as-is Work Order Update Use-as-is Work Order Update Use-as-is Large Fab  Date Step Qty Description of work order update Chief Eng Description of work order update Step Qty Or Non-conformance Chief Eng Description of work order update Use-as-is Large Fab  FAULT CATEGORY  Rework Skid-tube Machining Thermoforming Large Fab  Large Fab  Description of work order update Chief Eng Description Or Non-conformance Chief Eng Description Description Indicate Step	DISPOSITION  Rework Scrap Wachining Small Fab Machining Small Fab Work Order Update Initial Large Fab Composite  Date Step Qty Description of work order update or Non-conformance  FAULT CATEGORY  Gear General  Bending Centre Not Concentric to O/S BOM/Route Broken/Damaged Cracks  Cracks Broken/Damaged Instructions Incomplete  Crushed/Crimped Description  Grain Hardware Instructions Incomplete  Inspection Incomplete Instructions Incomplete  Instructions Incomplete/Unclear Maintenance  Machining Small Fab Machining Machinin	DISPOSITION  Rework Scrap Use-as-is Work Order Update Date Step Qty Description of work order update Or Non-conformance  Bending Centre Not Concentric to O/S BOM/Route Broken/Damaged Centre Not Concentric to O/S Gracks Broken/Damaged Customed Crushed/Crimped Burrs Instructions Incomplete Date Surp Surp Surp Surp Surp Surp Surp Surp	DISPOSITION Rework Scrap Use-as-is Work Order Update Date Step Qty Or Non-conformance Date Step Qty Or Non-conformance Date Step Composite Description Date Step Composite Date Step Composite Date Step Composite Date Date Step Composite Date Date Step Composite Date Date Step Composite Date Date Date Date Date Date Description Date Date Date Date Date Date Date Date	DISPOSITION  Rework Scrap Use-as-is Work Order Update Date:  Date Step Qty Description of work order update or Non-conformance Date:  FAULT CATEGORY  General Bending Centre Not Concentric to O/S Crasked Demonstration of Contamination Centre Not Concentric to O/S Crasked/Crimped Contamination Culffs  Crushed/Crimped Description of Work order update or Non-conformance Description Date Composite Description Date Composite Description Date Verification Date Verification Date Description Date Descri

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

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DART AEROSPACE LTD	Work Order:	106385
Description: Door Wedge	Part Number:	D3200-3
Inspection Dwg: D3200 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

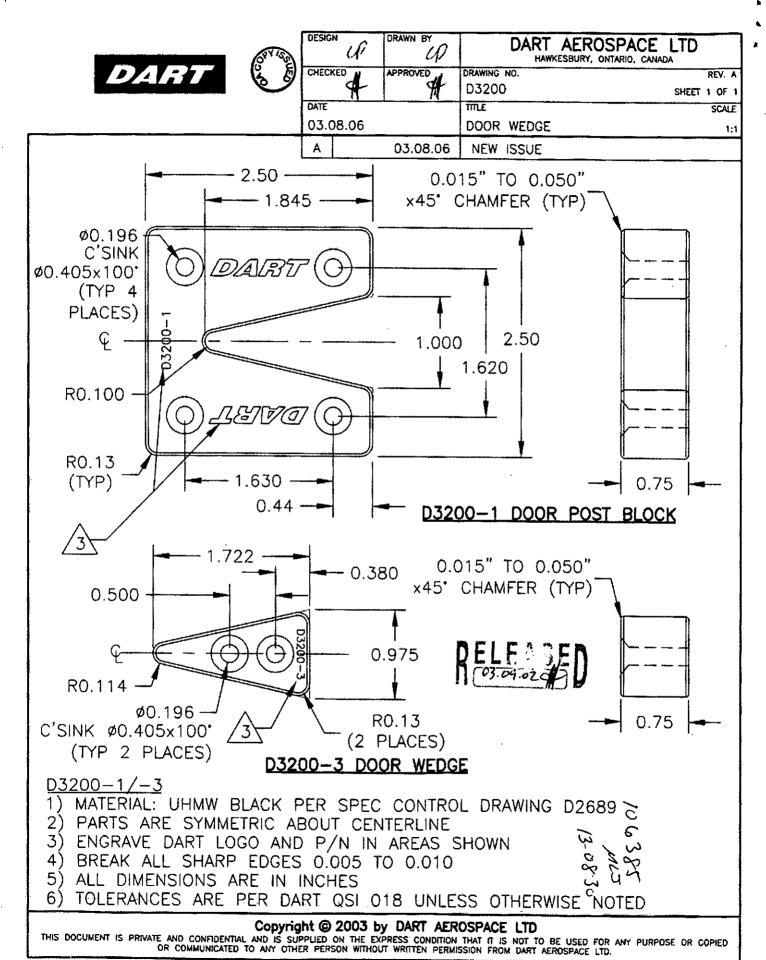
	х	First Arti	cle	Prot	otype
Drawing	Tolorones	Actual	Annant	Baisst	Metho
Dimension	Tolerance	Dimension	Accept	Reject	Inspe

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005/-0.000	0.196			Pin	SAUGE
0.405 x 100°	+/-0.010	.410	U		DR 05	6"UERN
0.500	+/-0.010	,500	V		DR85	6"VERN
1.722	+/-0.010	1.721			DR 05	6"NERN
0.380	+/-0.010	.379		,	DR US	6'VERN
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Measured by: DR/D.A	Audited by: 40	Prototype Approval:	N/A
Date: 13/09/08	Date: 13/09/01	Date:	N/A

Rev	Date	Change		Revised₁by	Approved
Α	03.11.12	New Issue	P/O D412-698-015	KJ/RF	14
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